

Work Order ID 45458

July 14, 2009 8:35:08 AM

Page 1

Item ID: D130-780-041

Accept

Revision ID: A

Item Name: SPACEPOD LH

Setup Start

Stop

Start Date: 7/14/09 Start Qty: 1.00

Required Date: 7/15/09 Req'd Qty: 1.00

Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

100

0.00



DC

Document Control

DOCUMENT CONTROL

Memo

Photocopy bluefile and type labels per PPP D130-780-041 CHG 001

for JLD 09/03/16

110

0.00



Packaging

Packaging

Pick Kit

Memo

0.00

120

0.00



Small Fab

Small Fab

Memo

-Assemble as per dwg D3188,
-use door to transfer drill hole location.
-Install inserts

MA. U

Work Order ID 45458

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Page 2

Item ID: D130-780-041

Accept



Setup Start



Revision ID: A

Stop



Item Name: SPACEPOD LH

Start Date: 7/14/09 Start Qty: 1.00



Cust Item ID:

Required Date: 7/15/09 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: Date: Tooling: Date:

Run Start



QC: Date: SPC (Y/N): Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00							
140 HandFinish Hand Finishing	Wing Walk as per dwg QSI005 4.4 Batch Memo TOP SURFACE OF POD	0.00 0.00							
150 QC Quality Control	QC3- Inspect Part Finish Memo	0.00 0.00							

N/A

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Item ID: D130-780-041

Accept



Setup Start



Revision ID: A

Stop



Item Name: SPACEPOD LH

Start Date: 7/14/09 Start Qty: 1.00



Cust Item ID:

Required Date: 7/15/09 Req'd Qty: 1.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160 	Pick Kit	0.00							
Packaging	Memo	0.00							
Packaging									
170 	QC4- 100% Inspect kits for completeness	0.00							
QC	Memo	0.00							
Quality Control									
180 		0.00							
Packaging	Memo	0.00							
Packaging	Identify and pack for shipping as per PPP D130-780-041								
	Location: _____								
	PPP Rev: _____								

Work Order ID 45458

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Item ID: D130-780-041

Accept



Setup Start



Revision ID: A

Stop



Item Name: SPACEPOD LH

Start Date: 7/14/09 Start Qty: 1.00



Cust Item ID:

Required Date: 7/15/09 Req'd Qty: 1.00



Customer:

Reference:

Run Start



Approvals: Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

190

QC21- Final Inspection - Work Order Release

0.00

07/07/14



QC

Memo

0.00

Quality Control

u 8.6.14

Picklist Print

July 14, 2009 8:35:07 AM

Page 1

Work Order ID: 45458

Parent Item: D130-780-041RevA

Parent Item Name: SPACEPOD LH



Comments:

Start Date: 7/14/09



Required Date: 7/15/09

Start Qty: 1.00



Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
✓ AN3-10A  Bolt		Purchased	No			160	Each	127.0000	2.0000 			

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	127	
111119	100	
17566	27	

✓ AN3-3A  Bolt		Purchased	No			160	Each	229.0000	4.0000 			
-------------------------------------------------------------------------------------------------------	--	-----------	----	--	--	-----	------	----------	-----------------------------------------------------------------------------------------------	--	--	--

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	229	
111925	229	

✓ AN3-6A  Bolt		Purchased	No			160	Each	127.0000	4.0000 			
---------------------------------------------------------------------------------------------------------	--	-----------	----	--	--	-----	------	----------	-------------------------------------------------------------------------------------------------	--	--	--

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	127	
106662	22	
107959	15	
109752	40	
112082	50	

Picklist Print

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Work Order ID: 45458

Parent Item: D130-780-041RevA

Parent Item Name: SPACEPOD LH

Comments:

Start Date: 7/14/09

Required Date: 7/15/09

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
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✓ AN525-10R7

Purchased

No

160

Each

268.0000

38.0000



Screw

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

268

110844

36

110914

12

111477

100

111965

120

AN526-832R24

Purchased

No

110

Each

213.0000

4.0000



Screw

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

213

16895

213

✓ AN526C832R14

Purchased

No

150

Each

1,051.000

8.0000



Screw

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

1051

104916

1051

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Shop Packet Print

Picklist Print

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Work Order ID: 45458

Parent Item: D130-780-041RevA

Parent Item Name: SPACEPOD LH


Comments:

Start Date: 7/14/09

Required Date: 7/15/09

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
✓ AN5-5A  Bolt		Purchased	No			160	Each	116.0000	1.0000			

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST 116

103585 3

110363 13

110865 100

✓ D3015-3RevB



Locknut

Manufactured No

160 Each 435.0000 1.0000



Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST 435

43758 26

44446 50

48238 359

Picklist Print

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Work Order ID: 45458

Parent Item: D130-780-041RevA

Parent Item Name: SPACEPOD LH



Comments:

Start Date: 7/14/09



Required Date: 7/15/09

Start Qty: 1.00



Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3538-1RevA  Hinge Bracket		Manufactured	No			110	Each	40.0000	2.0000 			

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	40	
44650	9	
46753	12	
48197	19	

✓ D3550-1RevB  Strut		Manufactured	No			160	Each	31.0000	1.0000 			
------------------------------------------------------------------------------------------------------------	--	--------------	----	--	--	-----	------	---------	-----------------------------------------------------------------------------------------------	--	--	--

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	31	
36226	5	
45570	6	
48367	20	

✓ D3554-7RevA  Ball Stud		Manufactured	No			160	Each	81.0000	1.0000 			
------------------------------------------------------------------------------------------------------------------	--	--------------	----	--	--	-----	------	---------	-------------------------------------------------------------------------------------------------	--	--	--

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	81	
37674	81	

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Shop Packet Print

Picklist Print

July 14, 2009 8:35:07 AM

Work Order ID: 45458

Parent Item: D130-780-041RevA

Parent Item Name: SPACEPOD LH



Comments:

Start Date: 7/14/09

Required Date: 7/15/09

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
✓ D3798-041RevA  Spacepod Floor		Manufactured	No			160	Each	3.0000	1.0000 			

Warehouse Loc Qty Loc Code
Location

Main Warehouse
ST

3

45578

3

✓ D3815-041RevA  Web Assembly		Manufactured	No			160	Each	17.0000	2.0000 			
---------------------------------------------------------------------------------------------------------------------	--	--------------	----	--	--	-----	------	---------	-----------------------------------------------------------------------------------------------	--	--	--

Warehouse Loc Qty Loc Code
Location

Main Warehouse
ST

17

45729

11

46356

6

✓ D3837-1RevB  Decal		Manufactured	No			160	Each	12.0000	1.0000 			
--------------------------------------------------------------------------------------------------------------	--	--------------	----	--	--	-----	------	---------	-------------------------------------------------------------------------------------------------	--	--	--

Warehouse Loc Qty Loc Code
Location

Main Warehouse
ST

12

46231

12

Picklist Print

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Work Order ID: 45458

Parent Item: D130-780-041RevA

Parent Item Name: SPACEPOD LH

Comments:

Start Date: 7/14/09

Required Date: 7/15/09

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
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D3837-3RevB

Manufactured

No

160

Each

11.0000

1.0000



Decal

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

11

46232

11

MS20426AD4-5

Purchased

No

110

Each

7,958.000

4.0000



Rivet

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

7958

4067

1141

6733

1835

6874

4982

MS21042L08

Purchased

No

110

Each

222.0000

4.0000



Nut

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

222

110002

24

111889

198

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Shop Packet Print

Picklist Print

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Work Order ID: 45458



Parent Item: D130-780-041RevA



Parent Item Name: SPACEPOD LH

Start Date: 7/14/09

Required Date: 7/15/09

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
✓ MS21042L3 Nut		Purchased	No			160	Each	1,795.000	16.0000			

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	1795	
110844	34	
111274	761	
111668	1000	

✓ MS24694-S67



Screw

Purchased

No

160

Each

167.0000

7.0000



<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	167	
101662	13	
106166	54	
111965	100	

Picklist Print

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Work Order ID: 45458

Parent Item: D130-780-041RevA

Parent Item Name: SPACEPOD LH



Comments:

Start Date: 7/14/09



Required Date: 7/15/09

Start Qty: 1.00



Required Qty: 1.00



Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
✓ MS24694-S69  Screw		Purchased	No			160	Each	27.0000	1.0000 			

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	27	
103574	7	
110153	20	

✓ NAS1149D0332J  Washer		Purchased	No			160	Each	248.0000	16.0000 			
---------------------------------------------------------------------------------------------------------------	--	-----------	----	--	--	-----	------	----------	------------------------------------------------------------------------------------------------	--	--	--

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	248	
110625	48	
110844	200	

✓ NAS1149D0363J  Washer		Purchased	No			160	Each	0.0000	8.0000 			
-----------------------------------------------------------------------------------------------------------------	--	-----------	----	--	--	-----	------	--------	-------------------------------------------------------------------------------------------------	--	--	--

NAS1149D0563J  Washer		Purchased	No			160	Each	0.0000	3.0000 			
---------------------------------------------------------------------------------------------------------------	--	-----------	----	--	--	-----	------	--------	-------------------------------------------------------------------------------------------------	--	--	--

Picklist Print

July 14, 2009 8:35:08 AM

Work Order ID: 45458

Parent Item: D130-780-041RevA

Parent Item Name: SPACEPOD LH


Comments:

Start Date: 7/14/09




Required Date: 7/15/09

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
NAS1149DN832J		Purchased	No			110	Each	107.0000	4.0000			
												
WASHER												

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	107	
110844	1	
111193	6	
111359	100	

✓ D130-780-043RevA	Manufactured	No		110	Each	0.0000	1.0000
							
Spacepod Door Assembly, LH							
D3188-1MRevE	Manufactured	No		110	Each	0.0000	1.0000
							
SPACEPOD BODY LH							
✓ D3547-1RevA	Manufactured	No		110	Each	20.0000	1.0000
							
Bracket							

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	20	
35455	20	

B45336

Picklist Print

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Work Order ID: 45458

Parent Item: D130-780-041RevA

Parent Item Name: SPACEPOD LH


Comments:

Start Date: 7/14/09

Required Date: 7/15/09

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
AKS4-1032-130		Purchased	No			110	Each	1.0000	28.0000			
												
Inserts												

Warehouse Loc Qty Loc Code
Location

Main Warehouse

ST

1

6087

1

D2237RevD1

Manufactured

No

110

Each

30.0000

2.0000



Striker Plate

Warehouse Loc Qty Loc Code
Location

Main Warehouse

ST

30

46162

30

✓ A3235-020-935

Purchased

No

160

Each

815.0000

8.0000



Washer - Countersunk

Warehouse Loc Qty Loc Code
Location

Main Warehouse

ST

815

104156

59

106150

756

July 14, 2009 8:35:08 AM

Shop Packet Print

Picklist Print

July 14, 2009 8:35:08 AM

Work Order ID: 45458

Parent Item: D130-780-041RevA

Parent Item Name: SPACEPOD LH


Comments:

Start Date: 7/14/09

Required Date: 7/15/09

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
MS21042L5  Nut		Purchased	No			160	Each	763.0000	1.0000			

7/11/227

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST

763

110382

10

111127

253

111636

500

7/11/229 10

AKS4-1032-130

Purchased

No

160

Each

1.0000

10.0000

Inserts

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST

1

6087

1

160

Each

5.0000

1.0000

D130-780-013RevA

Manufactured

No

SWITCH RELOCATION KIT

Warehouse Loc Qty Loc Code

Location

Main Warehouse

FG

5

45533

2

45534

1

46247

2

45534 18

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Shop Packet Print

Picklist Print

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Work Order ID: 45458



Parent Item: D130-780-041RevA



Parent Item Name: SPACEPOD LH

Start Date: 7/14/09

Required Date: 7/15/09

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D130-780-011		Manufactured	No			160	Each	0.0000	1.0000			
SPACEPOD												

July 14, 2009 8:35:08 AM

Shop Packet Print

Page 12

Date: Wednesday, 25/03/2009 10:54:35 AM
 User: Julie Dawson

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : SPACEPOD LH, EC 130 B4
Job Number : 45458	
Estimate Number : 13761	
P.O. Number :	Part Number : D130780041
This Issue : 25/03/2009 S.O. No. :	Drawing Number : IIN-D130-780
Prsht Rev. : NC	Project Number : N/A
First Issue : 03/02/2009 Type : PURCHASED PARTS	Drawing Revision : A
Previous Run :	Material :
Written By :	Due Date : 20/02/2009 Qty: 1 Um: Each
Checked & Approved By : <u>JUD 09.03.25</u>	
Comment : Est Rev:A 09-02-03 new issue DD verified by:JLM	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	DC	DOCUMENT CONTROL
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**Comment:** DOCUMENT CONTROL

Photocopy bluefile and type labels per PPP D130-780-041 CHG 001

509/02/14

2.0	D130780043	Spacepod Door Assembly, LH
-----	------------	----------------------------

**Comment:** Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Spacepod Door Assembly, LH

batch: 45536

3.0	D130780011	Door Hinge, Aft, LH
-----	------------	---------------------

**Comment:** Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Door Hinge, Aft, LH

batch: _____

4.0	D130780013	Switch Relocation
-----	------------	-------------------

**Comment:** Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Switch Relocation

batch: 45534

5.0	D31881M	SPACEPOD BODY LH
-----	---------	------------------

**Comment:** Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

SPACEPOD BODY LH

batch: 45696A

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 25/03/2009 10:54:35 AM
User: Julie Dawson

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SPACEPOD LH, EC 130 B4

Job Number: 45458

Part Number: D130780041

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

AKS71032130

Insert



Comment: Qty.: 28.0000 Each(s)/Unit Total : 28.0000 Each(s)

Insert

batch: _____

7.0

D38373

Decal



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Decal

batch: _____

8.0

D2237

Striker Plate



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Striker Plate

batch: _____

9.0

MS20426AD45

Rivet



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Rivet

batch: _____

10.0

D35381

Hinge Bracket



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Hinge Bracket

batch: _____

11.0

D2179

Doubler



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Doubler

batch: _____

12.0

AN526C832R24

screw



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

screw

batch: _____

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 25/03/2009 10:54:35 AM
User: Julie Dawson

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SPACEPOD LH, EC 130 B4

Job Number: 45458

Part Number: D130780041

Job Number:



Seq. #:

Machine Or Operation:

Description :

13.0

NAS1149DN832J

Washer



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)
Washer
batch: _____

14.0

MS21042L08

Nut



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)
Nut
batch: _____

15.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1
-Assemble as per dwg D3188,
-use door to transfer drill hole location.
-Install inserts

16.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

17.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1
Wing Walk Spacepod top surface of Pod as per Dwg D3188 & QSI 005 4.4
Batch: _____

18.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

19.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1
pick kit:

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 25/03/2009 10:54:35 AM
User: Julie Dawson

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SPACEPOD LH, EC 130 B4

Job Number: 45458

Part Number: D130780041

Job Number:



Seq. #:

Machine Or Operation:

Description :

20.0



D3815041

Web Assembly



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Web Assembly

batch: B46729

21.0



D38371

Decal



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Decal

batch: B46231

22.0



D30153

Locknut



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Locknut

batch: 48238

23.0



D3798041

Spacepod Floor, LH



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Spacepod Floor, LH

batch: 45878

24.0



D35471

Bracket



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Bracket

batch: B35408

25.0



D35501

Strut



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Strut

batch: 36226

26.0



D35547

Ball Stud



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Ball Stud

batch: B37674

CE 9/7/14

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 25/03/2009 10:54:35 AM
User: Julie Dawson

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SPACEPOD LH, EC 130 B4

Job Number: 45458

Part Number: D130780041

Job Number:



Seq. #:

Machine Or Operation:

Description :

27.0

AN33A

Bolt



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Bolt

batch: M111925

28.0

AN36A

Bolt



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Bolt

batch: M109752

29.0

AN310A

Bolt



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Bolt

batch: M11566

30.0

AN55A

Bolt



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Bolt

batch: M110363

31.0

AN52510R7

Screw



Comment: Qty.: 38.0000 Each(s)/Unit Total : 38.0000 Each(s)

Screw

batch: M111477

32.0

AN526C832R14

Screw



Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)

Screw

batch: M104916

33.0

MS24694S67

Screw



Comment: Qty.: 7.0000 Each(s)/Unit Total : 7.0000 Each(s)

Screw

batch: M106166

Page 5 of 14

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 25/03/2009 10:54:35 AM
User: Julie Dawson

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SPACEPOD LH, EC 130 B4

Job Number: 45458

Part Number: D130780041

Job Number:



Seq. #:

Machine Or Operation:

Description :

34.0



MS24694S69

Screw



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Screw

batch: M110103

35.0



A3235020935

Washer - Countersunk



Comment: Qty.: 8.0000 Each(s)/Unit Total: 8.0000 Each(s)

Washer - Countersunk

batch: M104156

36.0



NAS1149D0363J

Washer

AN96-0010

Q51-4-211



Comment: Qty.: 8.0000 Each(s)/Unit Total: 8.0000 Each(s)

Washer

batch: M111668

37.0



NAS1149D0332J

Washer

AN96-0010L

Q51-4-211



Comment: Qty.: 16.0000 Each(s)/Unit Total: 16.0000 Each(s)

Washer

batch: M119632

38.0



NAS1149D0563J

Washer

AN96-0010L

Q51-4-211



Comment: Qty.: 3.0000 Each(s)/Unit Total: 3.0000 Each(s)

Washer

batch: M111279

39.0



MS21042L3

Nut



Comment: Qty.: 16.0000 Each(s)/Unit Total: 16.0000 Each(s)

Nut

batch: M111274

40.0



MS21042L5

Nut



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Nut

batch: M11127

69/1/14 (C)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 25/03/2009 10:54:35 AM
User: Julie Dawson

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SPACEPOD LH, EC 130 B4

Job Number: 45458

Part Number: D130780041

Job Number:



Seq. #:

Machine Or Operation:

Description :

41.0

✓ ALS71032130

Insert



Comment: Qty.: 10.0000 Each(s)/Unit Total: 10.0000 Each(s)

ALS7-1032-130

batch:

(AKS7-1032-130)

ALS77-1032-130 M111155

9/7/14

42.0

✓ QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

50967/14

43.0

✓ PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D130-780-041

Location:

PPP Rev:

PPA

9/7/14

44.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

5.0 PARTS LIST

-041	-042	-043	-044	-011	-013	Part Number	Description
X						D130-780-041	SPACEPOD™ LH, EC 130 B4
	X					D130-780-042	SPACEPOD™ RH, EC 130 B4
1		X				D130-780-043	DOOR ASSEMBLY, LH
	1		X			D130-780-044	DOOR ASSEMBLY, RH
1				X		D130-780-011	AFT LH DOOR HINGE KIT
1	1				X	D130-780-013	SWITCH RELOCATION KIT
2	2					D3815-041	WEB ASSEMBLY
						D2464-0360	NEOPRENE SEAL
		1	1			D2589	KEYS, KEY CHAIN
1	1					D3837-1	DECAL
1	1					D3015-3	LOCK NUT
		1				D3186-3	SPACEPOD™ DOOR, LH
			1			D3186-4	SPACEPOD™ DOOR, RH
1						D3798-041	FLOOR
	1					D3798-042	FLOOR
1						D3188-5	SPACEPOD™ BODY
	1					D3188-6	SPACEPOD™ BODY
1	1					D3547-1	BRACKET
1	1					D3550-1	STRUT
		1	1			D3552-7	GAS SPRING
1	1					D3554-7	BALL STUD
4	4					AN3-3A	BOLT
4	4					AN3-6A	BOLT
2	2					AN3-10A	BOLT
1	1					AN5-5A	BOLT
38	38					AN525-10R7	SCREW
8	8					AN526C832R14	SCREW
7	7					MS24694S67	SCREW
1	1					MS24694S69	SCREW
		2	2			MS27039-0811	SCREW
8	8					A3235-020-935	WASHER
8	8					NAS1149D0363J	WASHER
16	16					NAS1149D0332J	WASHER
		4	4			NAS1149DN832J	WASHER
3	3					NAS1149D0563J	WASHER
		2	2			NAS1515H3	NYLON WASHER
		2	2			MS21042L08	NUT
16	16					MS21042L3	NUT (or MS21042-3)
1	1					MS21042L5	NUT
10	10					AKS7-1032-130	INSERT
28**	28**					AKS7-1032-130	INSERT
					2	D3819-1	MALE SPADE CONNECTOR
					2	D3597-1	FEMALE SPADE CONNECTOR

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-041	-042	-043	-044	-011	-013	Part Number	Description
					1	D3598-2-096	EXPANDABLE SLEEVE
					24	D3599-1	TIE-WRAP
					24	D3600-1	TIE-WRAP MOUNT
					24 FT	M22759/41-22-9	WIRE
		1*	1*			D2464-1250	NEOPRENE SEAL
1**		1*				D3837-3	DECAL
	1**		1*			D3837-4	DECAL
		2*	2*			D2586	LATCH
		2*	2*			D2585	MOUNTING CHANNEL
		2*	2*			D2621	LATCH PLATE
		2*	2*			MS27039-1-15	SCREW
		2*	2*			NAS1149D0363J	WASHER
		2*	2*			MS21042L3	NUT (or MS21042-3)
		1*	1*			D2857-1	HINGE BRACKET
		1*	1*			D2857-2	HINGE BRACKET
		2*	2*			D2228	BACKING PLATE
		8*	8*			AN526C832R10	SCREW
		8*	8*			NAS1149DN832J	WASHER
		8*	8*			MS21042L08	NUT
		1*	1*			D3557-1	BRACKET
		2*	2*			D2228	BACKING PLATE
		1*	1*			D3554-7	BALL STUD
		1*	1*			NAS1149D0563J	WASHER
		1*	1*			D3015-3	LOCK NUT
		2*	2*			AN526C832R14	SCREW
		2*	2*			AN526C832R10	SCREW
		4*	4*			NAS1149DN832J	WASHER
		4*	4*			MS21042L08	NUT
2**	2**					D2237	STRIKER PLATE
4**	4**					MS20426AD4-5	RIVET
2**	2**					D3538-1	HINGE BRACKET
2**	2**					D2179	HINGE BRACKET PLATE
4**	4**					AN526C832R24	SCREW
4**	4**					NAS1149DN832J	WASHER
4**	4**					MS21042L08	NUT
				1		D3813-041	HINGE ASSEMBLY, UPPER DOOR
				1		D3813-043	HINGE ASSEMBLY, LOWER DOOR
				2***		D3518-3	ROD END
				2***		NAS509-6	NUT
				1		D3814-1	HINGE, UPPER AIRFRAME
				1		D3814-3	HINGE, LOWER AIRFRAME

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REVISIONS

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REVISIONS

-041	-042	-043	-044	-011	-013	Part Number	Description
				2		D3816-1	SPACER
				4		D3816-3	SPACER
				1		D3817-041	ANCHOR PLATE
				2		AN3-5A	BOLT
				3		AN3-7A	BOLT
				2		AN310-4	CASTLE NUT
				2		AN4-17	BOLT
				2		AN970-4	WASHER
				5		MS21042L3	NUT
				2		MS24665-212	COTTER PIN
				3		MS24694S46	SCREW
				8		NAS1149D0363J	WASHER
				2		NAS1149D0463J	WASHER
				1		D3552-7	GAS SPRING
				2		D3622-1	BALL STUD
				1		D3820-1	DOOR SUPPORT
				2		MS21042L5	NUT
				2		NAS1149D0563J	WASHER

* Pre-installed on D3186-3/-4 Spacepod™ Door

** Pre-installed on D3188-5/-6 Spacepod™

*** Pre-installed on D3813-041/-043 Hinge Assemblies

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Revision: **A**

Date: 08.10.07

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DESIGN JB	DRAWN BY CB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED LE	APPROVED [Signature]	DRAWING NO. D3188	REV. E; SHEET 1 OF 11
DATE 07.04.02		TITLE SPACEPOD BODY	SCALE NTS
A	03.04.03	NEW ISSUE	
B	06.10.06	UPDATED DWG TO MATCH PRODUCT ADDED D3188-1M/-2M/-3M/-5/-6/-7	
C	06.12.13	REMOVED D0600-XXX LABELS	
D	07.02.22	UPDATE DIMENSIONS	
E	07.04.02	ADD HYSOL/FIBER OPTION ON SHEET 11	

RELEASED07.04.09 **[Signature]****GENERAL NOTES:**

- 1) REFERENCE DIMENSIONS MATCH AIRCRAFT CONTOUR AND DOOR OPENING
- 2) LAMINATE PER DART QSI 006. LAMINATION SCHEDULE PER THIS DRAWING

3) MATERIALS:

RESIN: EPOCAST 50-A/9816 OR DERAKANE 470-36/411/510A40

FIBER: 9.7 oz 7781 WEAVE "S" GLASS (9 oz SATIN)
12 oz UNIDIRECTIONAL FIBERGLASS ("12 oz UNIDIRECTIONAL")
18 oz ROVING "E" GLASS (18 oz CLOTH)
OWENS CORNING MILLED FIBERS, "E" GLASS
3M K20 GLASS BUBBLESFOAM: A500 CORE CELL
OR DIVINYCELL
OR AIREX
OR KLEGECELL
FILL VOIDS IN FOAM WITH PASTE MADE FROM MILLED FIBERS & RESIN**4) MOLD SCHEDULE:**

PART	LAYUP	TRIM AND DRILL
D3188-1M/-1/-5	DT8003	DT8501
D3188-2M/-2/-6	DT8004	DT8502
D3188-3M/-3/-7	DT8500	DT8501

- 5) APPLY ANTI-SKID PAINT TO TOP SURFACE OF PODS PER QSI 005 4.4

FINISH: INSIDE/OUTSIDE WITH GREY DUPONT HIGHBUILD PRIMER 1144-S

ALL DIMENSIONS ARE IN INCHES

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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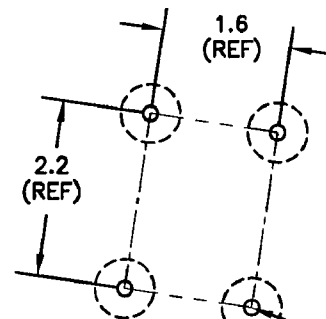
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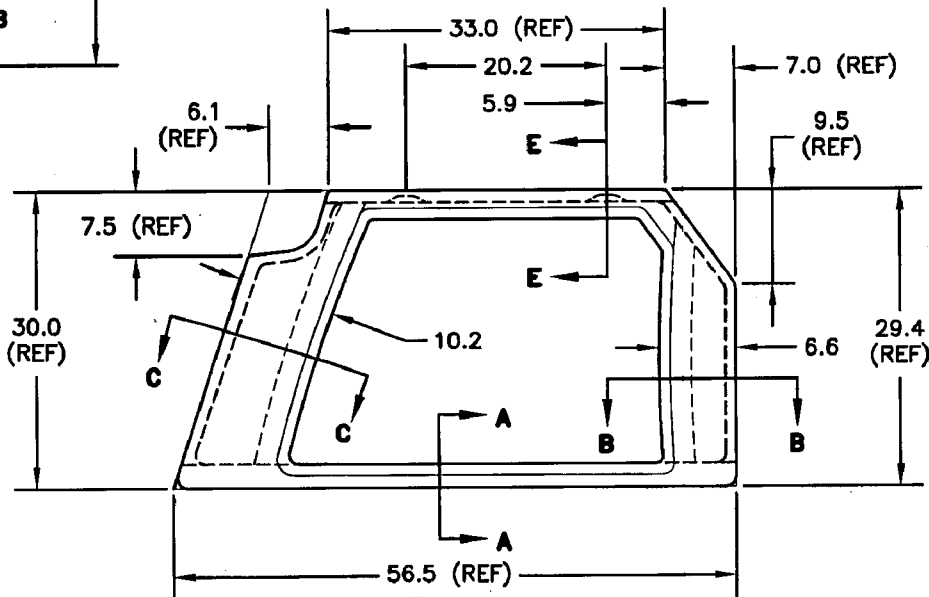
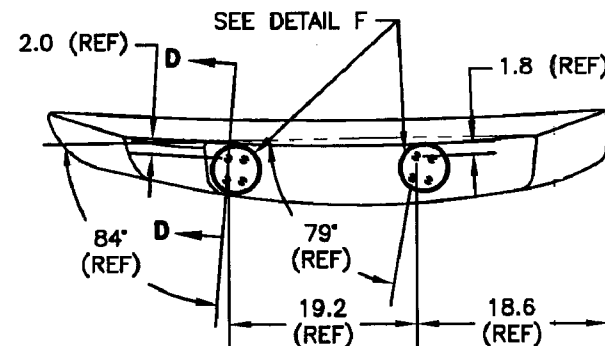
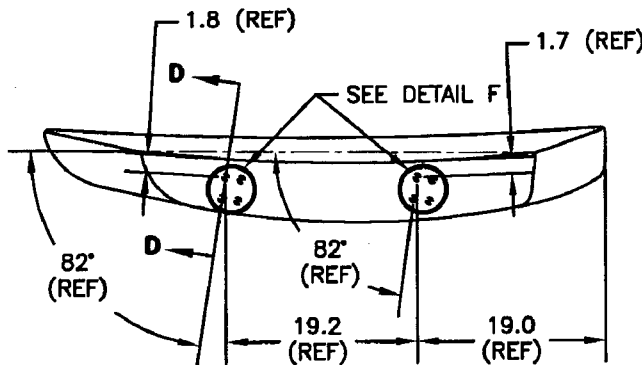
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07-04-02

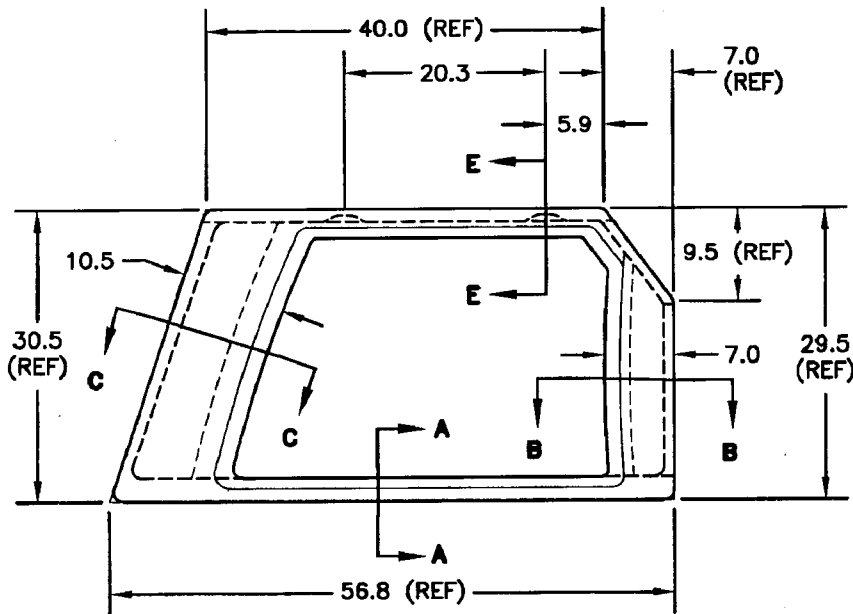
INSTALL
D2213 SPACER
(8 PLACES)
(SEE SECTION D-D)



DETAIL F



D3188-3M SPACEPOD BODY



D3188-1M SPACEPOD BODY

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D3186-1M/-3M NOTES:

- 1) REFERENCE DIMENSIONS ARE FROM DT8003/DT8500 AND DT8501.
- 2) SEE SHEET #4 FOR SECTION VIEWS.

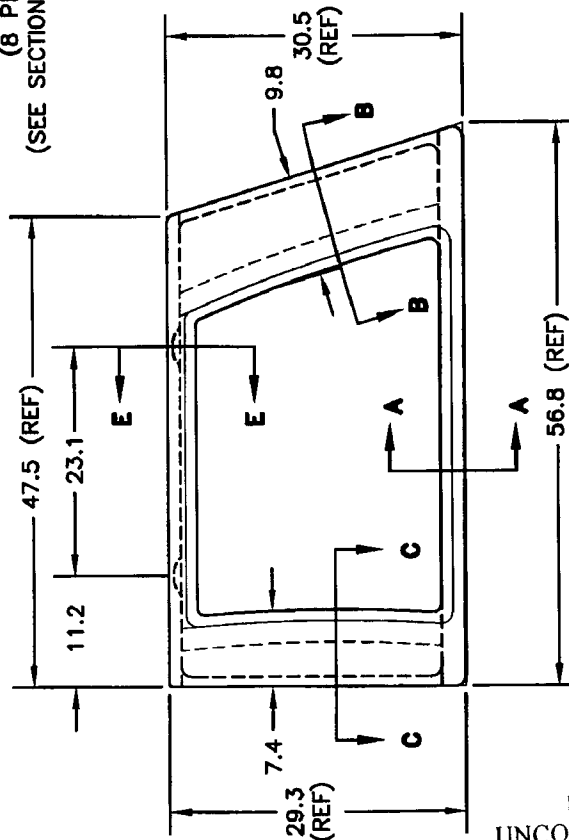
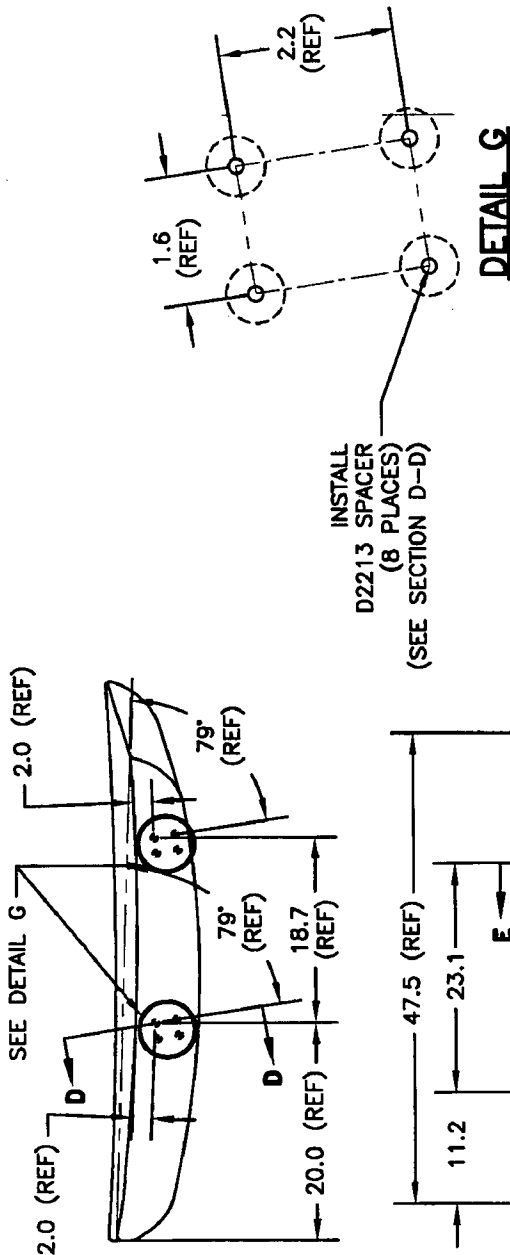
DESIGN	JB	DRAWN BY	CB	DART AEROSPACE LTD
CHECKED	CE	APPROVED	CE	HAWKESBURY, ONTARIO, CANADA
DATE	07.04.02	DRAWING NO.	D3188	REV. E.
TITLE	SPACEPOD BODY	SHEET 2 OF 11	SCALE	
				NTS



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DATE 07.04.02		TITLE SPACEPOD BODY	SCALE NTS

RELEASED

07.04.01 **[Signature]**



D3188-2M SPACEPOD BODY

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No. **1588**

D3188-2M NOTES:
1) REFERENCE DIMENSIONS ARE FROM DT8004 AND DT8502.
2) SEE SHEET #4 FOR SECTION VIEWS.

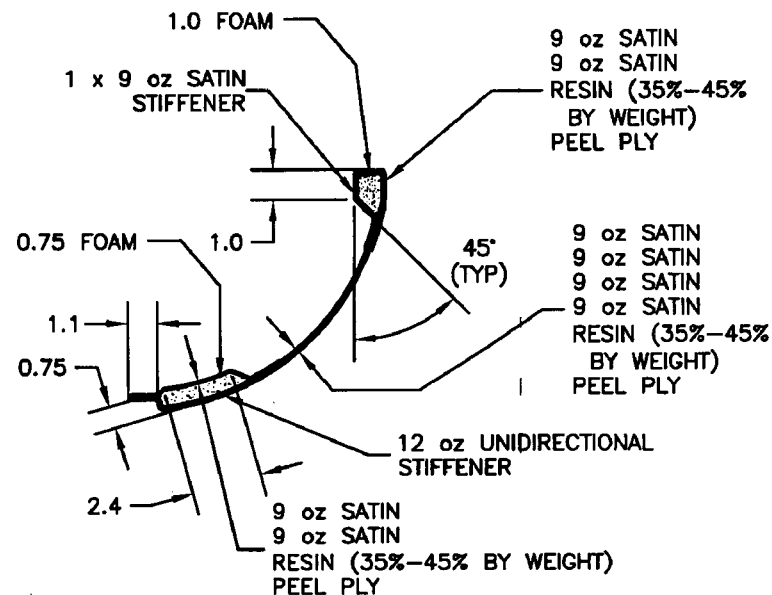
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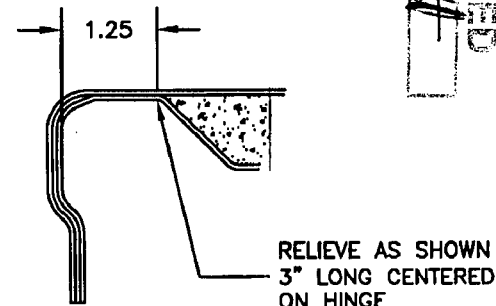
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JB	CB	HAWKESBURY, ONTARIO, CANADA	
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DATE 07.04.02	TITLE SPACEPOD BODY	SCALE NTS	

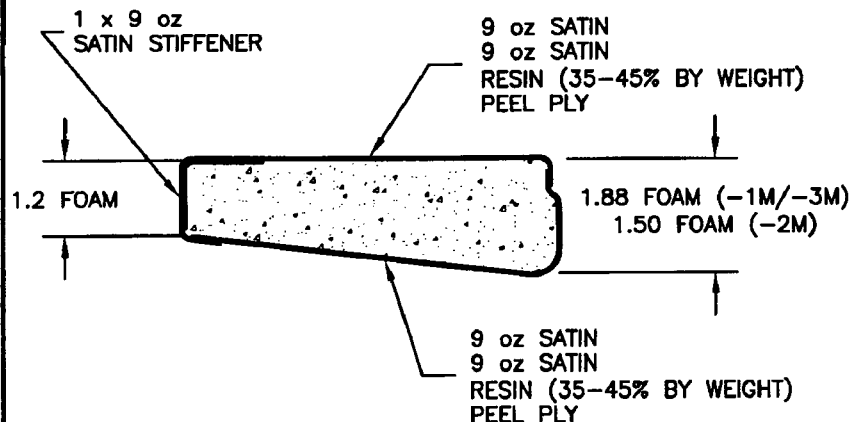
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[Signature]



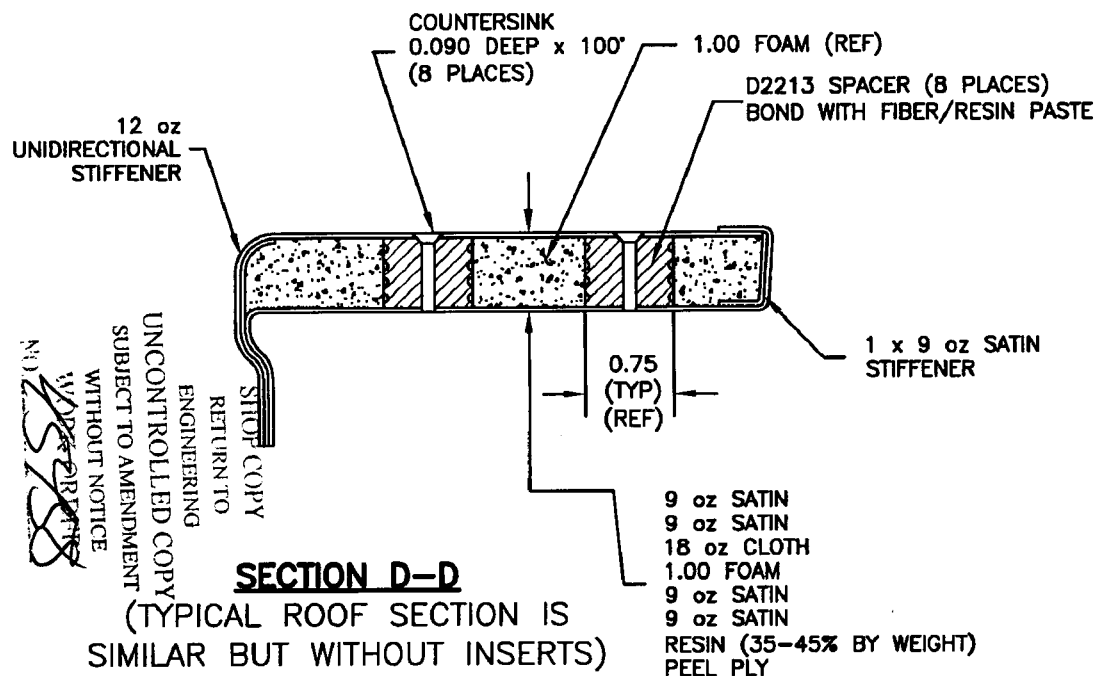
SECTION B-B
(SECTION C-C OPPOSITE)



SECTION E-E
(2 PLACES PER POD)



SECTION A-A
(TYPICAL FLOOR SECTION)



SECTION D-D
(TYPICAL ROOF SECTION IS
SIMILAR BUT WITHOUT INSERTS)

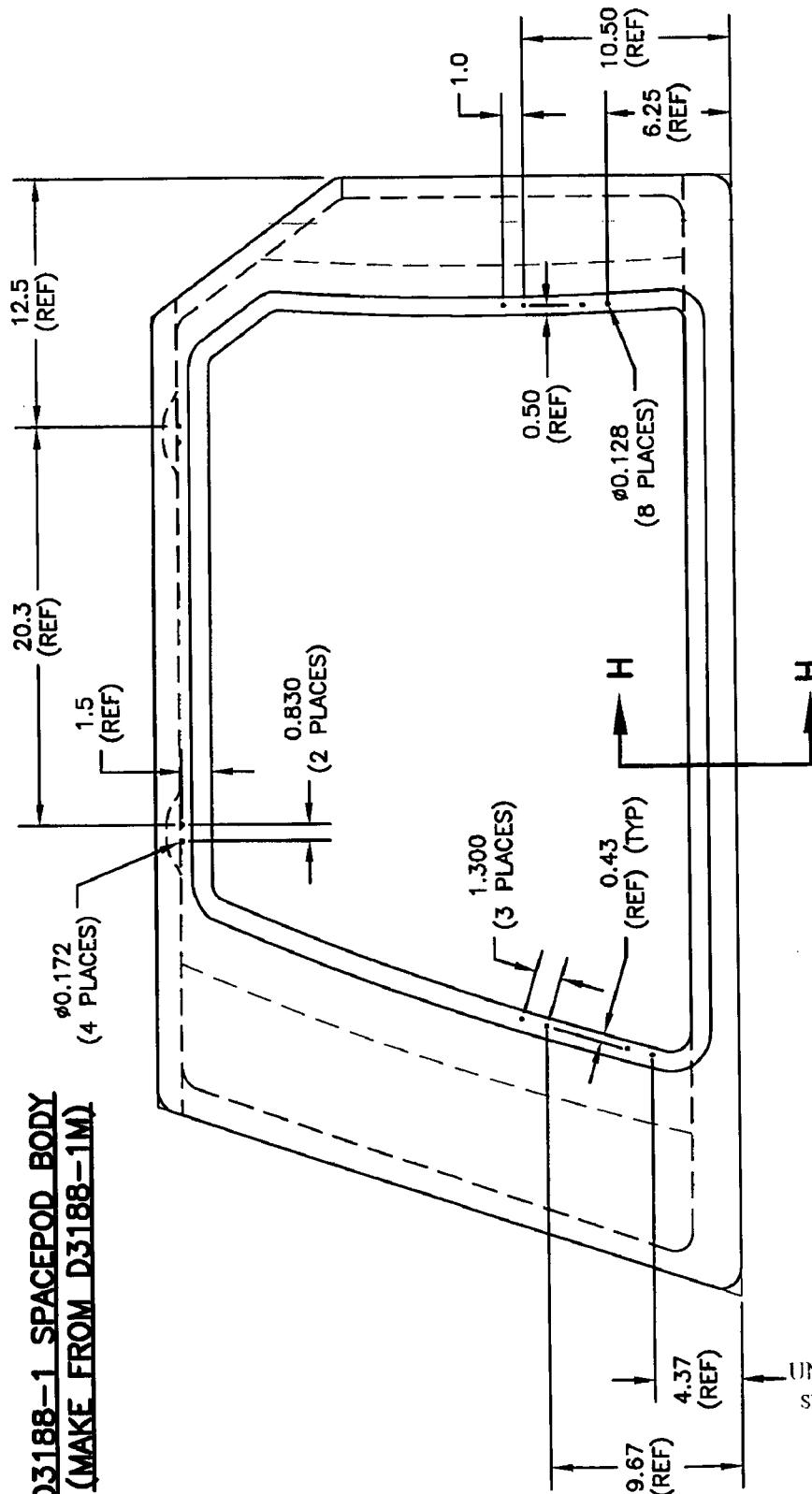
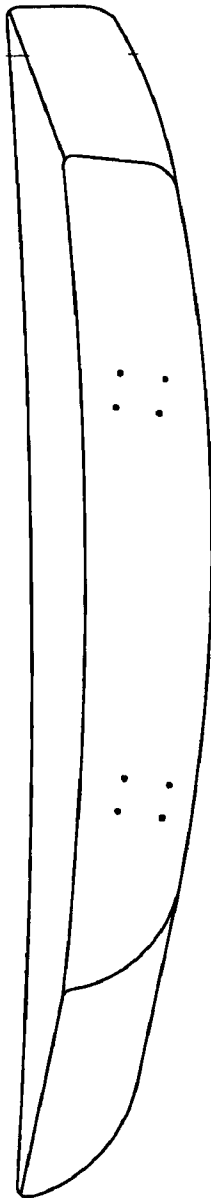
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DATE 07.04.02		TITLE SPACEPOD BODY	SCALE NTS

RELEASED

07.04.02



**D3188-1 SPACEPOD BODY
(MAKE FROM D3188-1M)**

- NOTES:
- 1) REFERENCE DIMENSIONS REPRESENT HOLES WHICH ARE TRANSFER DRILLED FROM D3186-1 DOOR DURING ASSEMBLY
 - 2) SEE SHEET #11 FOR SECTION VIEW

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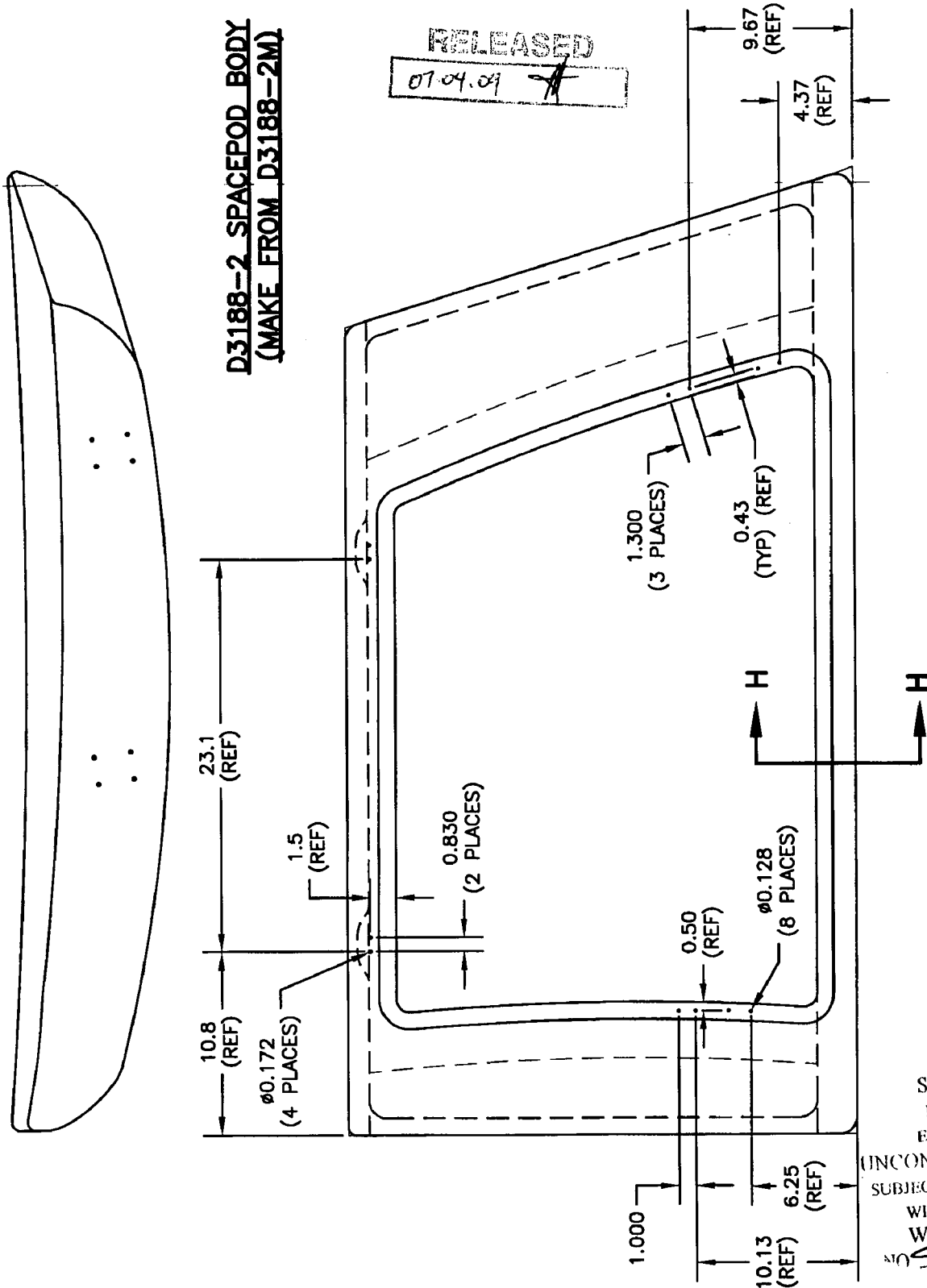
1398

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DATE 07.04.02		TITLE SPACEPOD BODY	SCALE NTS



NOTES:

- 1) REFERENCE DIMENSIONS REPRESENT HOLES WHICH ARE TRANSFER DRILLED FROM D3186-2 DOOR DURING ASSEMBLY
- 2) SEE SHEET #11 FOR SECTION VIEW

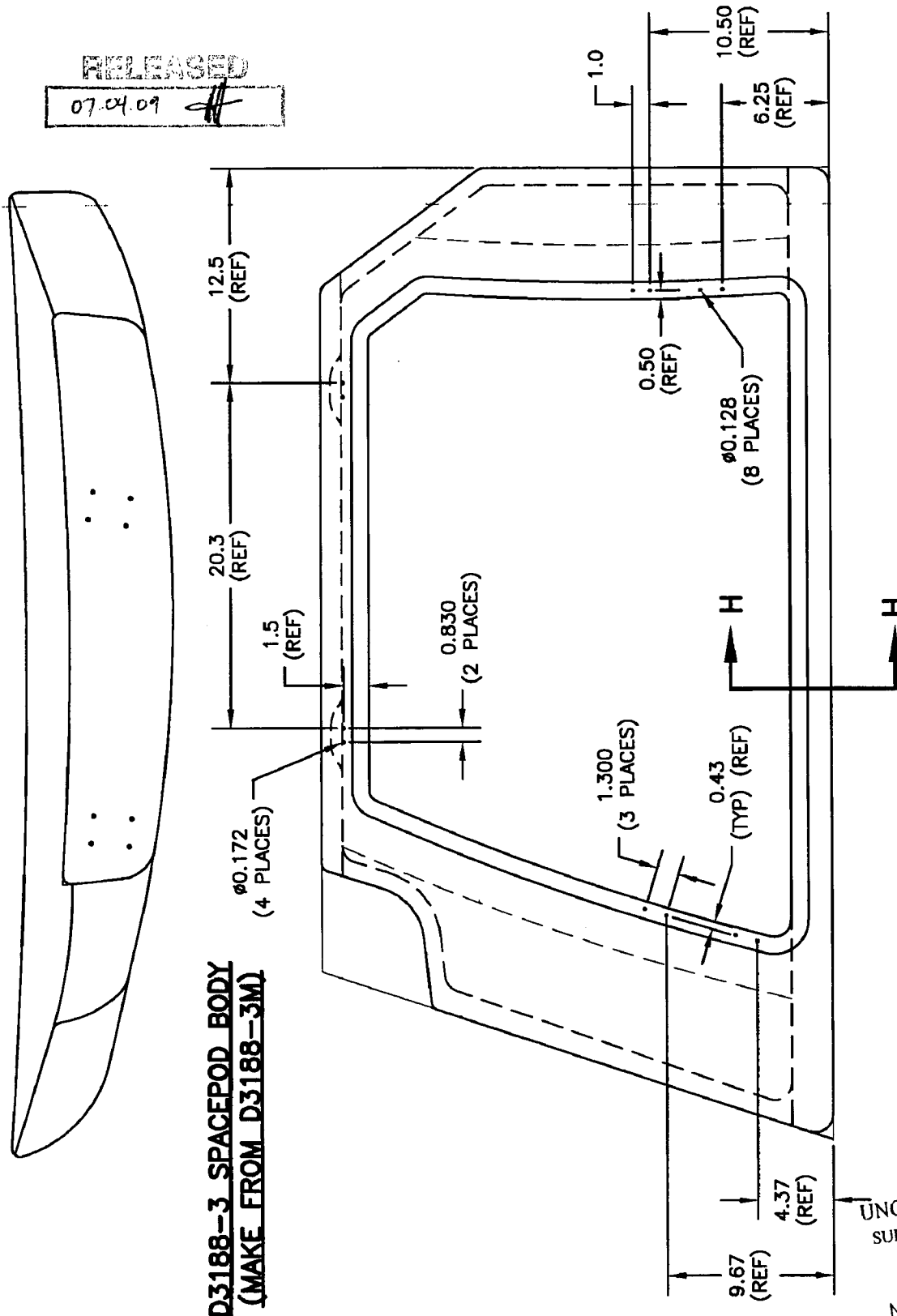
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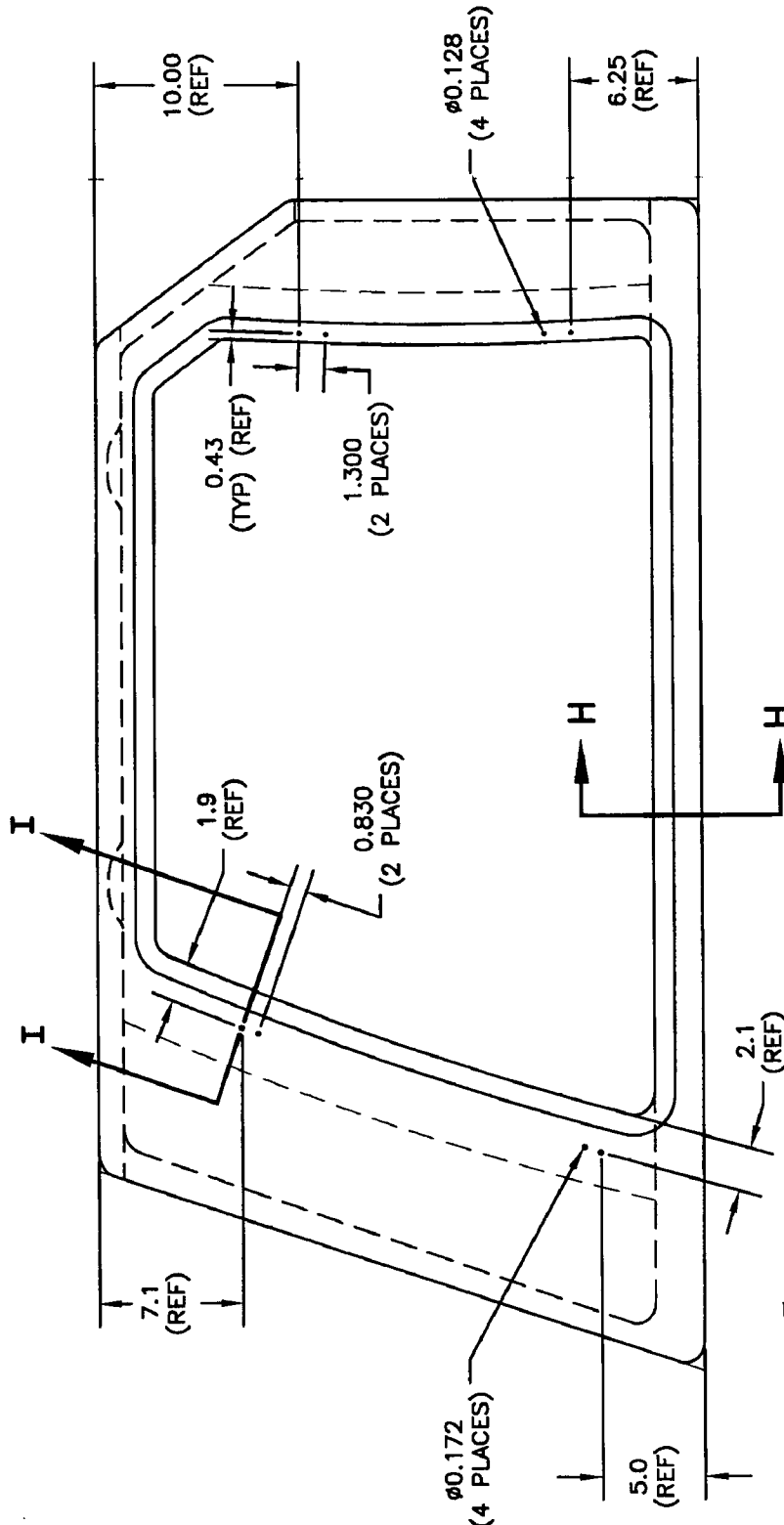
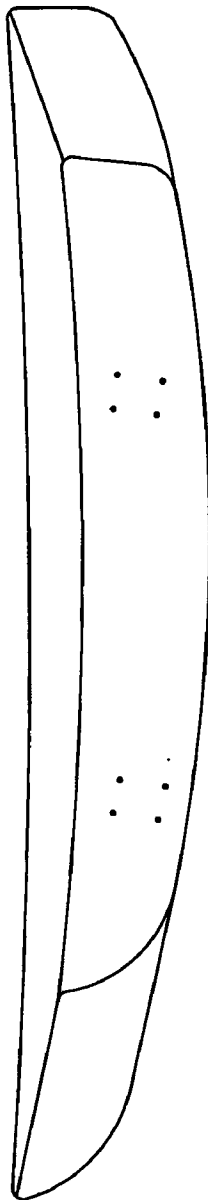


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DATE 07.04.02	TITLE SPACEPOD BODY		SCALE NTS

RELEASED

07.04.02

D3188-5 SPACEPOD BODY
(MAKE FROM D3188-1M)



NOTES:

- 1) REFERENCE DIMENSIONS REPRESENT HOLES WHICH ARE TRANSFER DRILLED FROM D3186-3 DOOR DURING ASSEMBLY
- 2) SEE SHEET #11 FOR SECTION VIEWS

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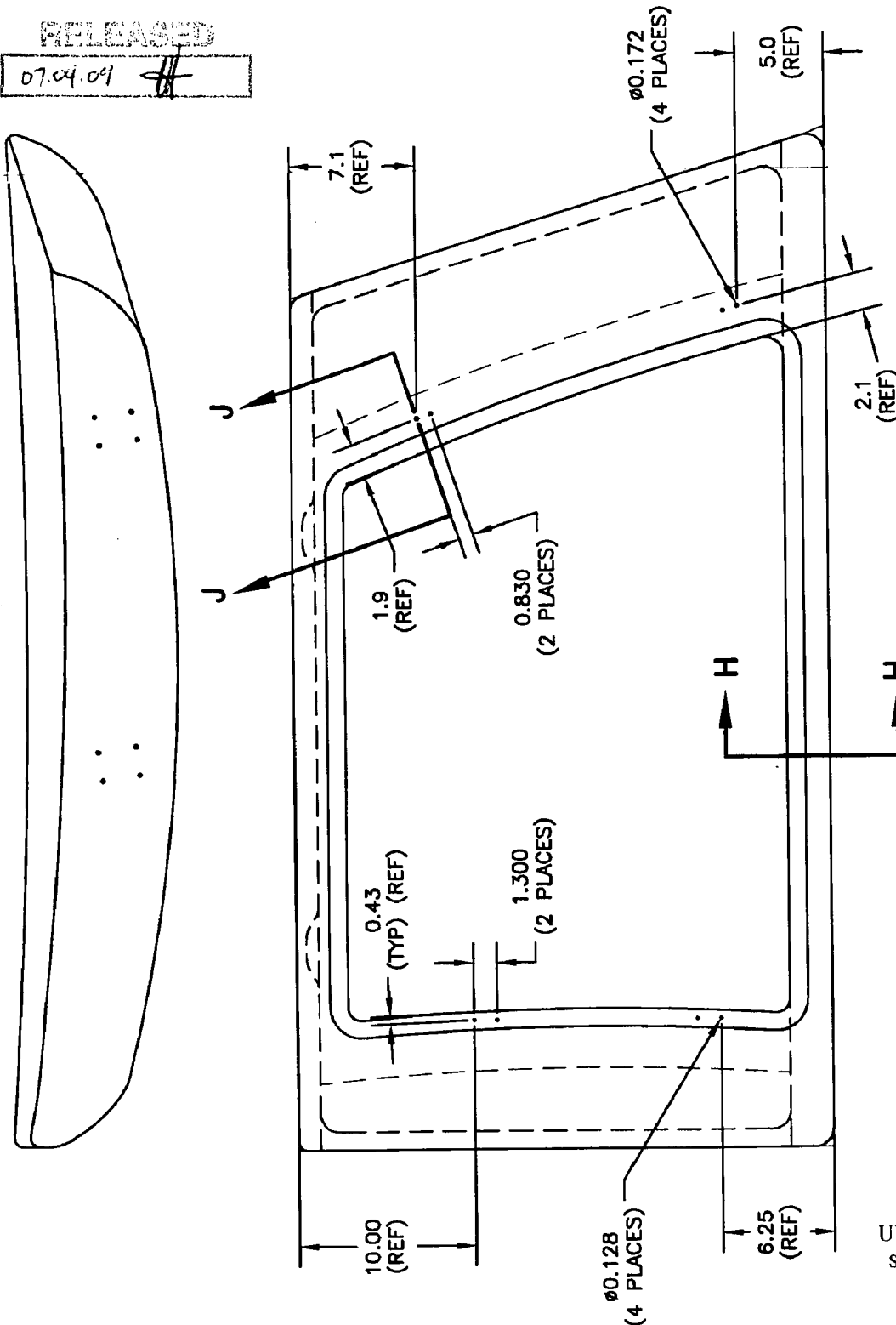
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DATE 07.04.02		TITLE SPACEPOD BODY	SCALE NTS

RELEASED

07.04.02

D3188-6 SPACEPOD BODY
(MAKE FROM D3188-2M)



NOTES:

- 1) REFERENCE DIMENSIONS REPRESENT HOLES WHICH ARE TRANSFER DRILLED FROM D3186-4 DOOR DURING ASSEMBLY
- 2) SEE SHEET #11 FOR SECTION VIEWS

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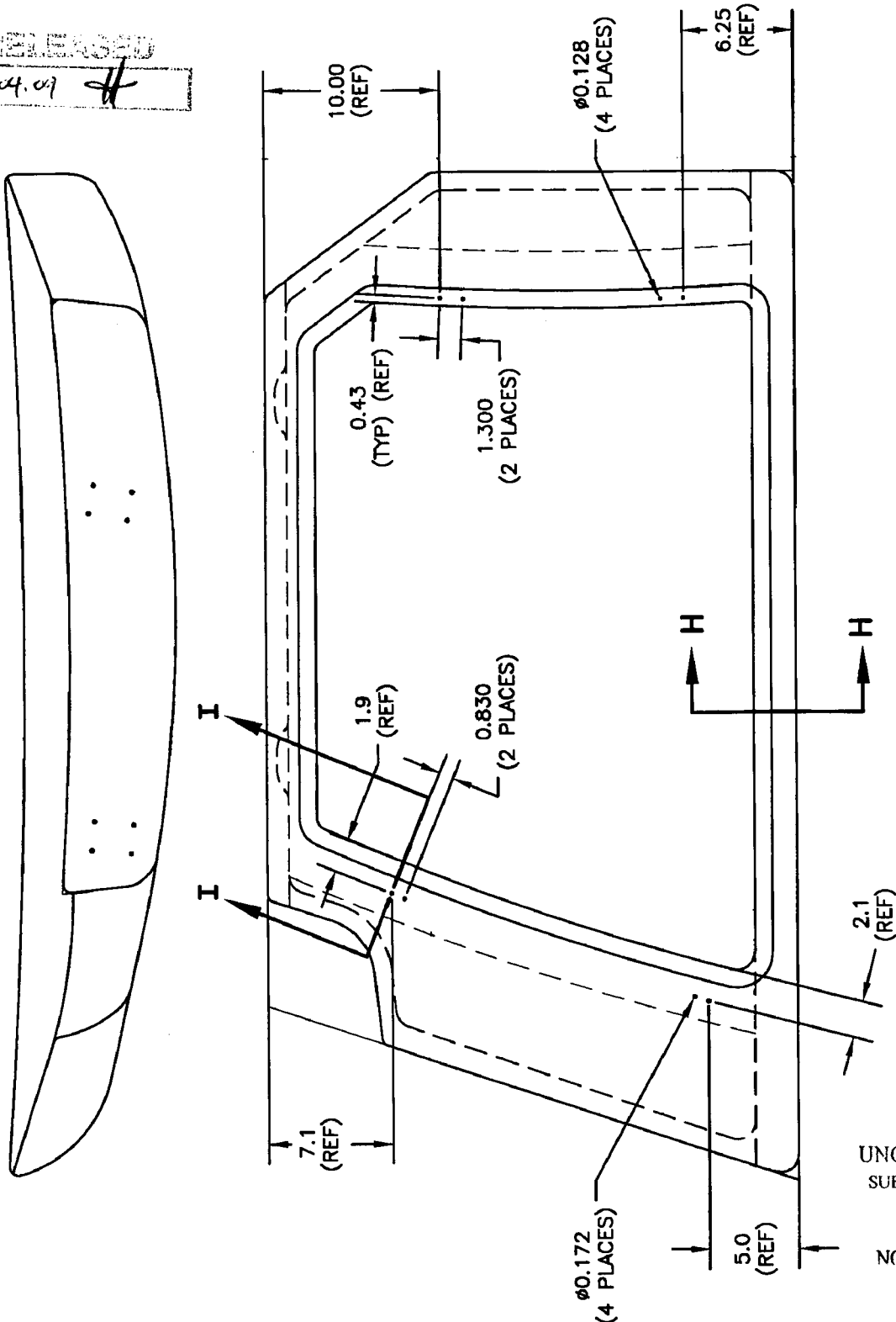
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DATE 07.04.02	TITLE SPACEPOD BODY		SCALE NTS

RELEASED

07.04.02

**D3188-7 SPACEPOD BODY
(MAKE FROM D3188-3M)**



NOTE:

- 1) REFERENCE DIMENSIONS REPRESENT HOLES WHICH ARE TRANSFER DRILLED FROM D3186-3 DOOR DURING ASSEMBLY
- 2) SEE SHEET #11 FOR SECTION VIEWS

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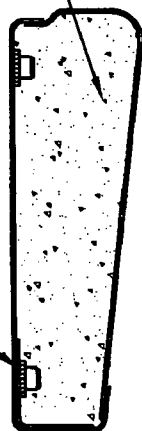
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DATE 07.04.02		TITLE SPACEPOD BODY	SCALE NTS

RELEASED

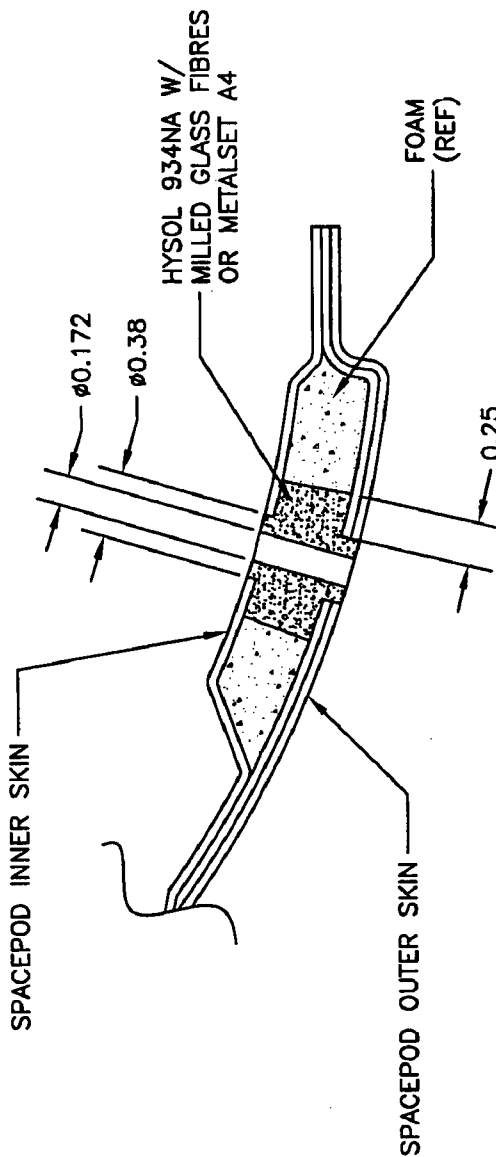
07.04.02

INSTALL AKS7-1032-130
INSERTS (29 PLACES)
PER D3188-1T1 (D3188-1/-3/-5/-7)
OR D3188-2T1 (D3188-2/-6)

FOAM
(REF)



SECTION H-H
(TYPICAL FLOOR SECTION)



SECTION I-I
(SECTION J-J OPPOSITE)
(4 PLACES PER POD)

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